

Work Order ID 146824

Tuesday, May 24, 2016 9:55:33 AM

146824

U/R

FUR BELL

Page 1

Item ID: D412-761-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: URF 16-533 Stop *NS2*
 Item Name: Bubble Window

Start Date: 5/26/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 6/1/2016 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	Rev E U/K OK <u>9/16/13/1</u>								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-045 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

DAS
6
9-89

2 DAS
27
9-89

JUN 3 0 2016

2 DAS
28
9-89

DAS
28
9-89

JUN 15 2016

2 DAS
27
9-89

JUN 3 0 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Tuesday, May 24, 2016 9:55:33 AM

Item ID: D412-761-045

Accept

N900040100

Setup Start *NS1*

Revision ID: URF 16-533

Stop *NS2*

Item Name: Bubble Window

Start Date: 5/26/2016 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/1/2016 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

130

0.00

130

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D412-761-045

Location:

PPP Rev: PPP 46880 XI

~~PPP~~ PPP146880 X1

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.20

Quality Control

2x

DAS 27 ~~9-39~~ DAS 28 9-89

JUN 30 2016

DAS
16
9-89

26/06/32

2m 16/06/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Description Work Order Deviation				Disposition				Completed By																																																							
Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Picklist Print

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Page 1

Work Order ID: 146824

146824

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 5/26/2016

Required Date: 6/1/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC 13.01.15 as per ECN13-511 DD Verf:JLM IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3704-3 *D3704-3* Escutcheon		Manufactured	No			110	Each	1.0000	1	2			
	DAS 27 9-89				<u>Location</u> ST052 145721 147090 112355				**	B148133X2		DAS 6 9-89	DAS 28 9-89
NAS43DD3-24 *NAS43DD3-24* Spacer for bolt		Purchased	No				Each	44.0000	1	2			
	DAS 27 9-89				<u>Location</u> ST550 M128454				**			DAS 6 9-89	DAS 28 9-89
D412-761-043 *D412-761-043* Modified Latch Mechanism, LH		Manufactured	No			110	Each	0.0000	1	2			
	DAS 27 9-89								**	146012		DAS 6 9-89	DAS 28 9-89
D3676-1 *D3676-1* Bubble Window, LH		Manufactured	No			110	Each	0.0000	1	2			
	DAS 27 9-89								**	B144875X1		DAS 6 9-89	DAS 28 9-89
D3678-1 *D3678-1* Placard		Manufactured	No			110	Each	7.0000	1	2			
	DAS 27 9-89				<u>Location</u> ST051 139501 145256				**	B144875X1		DAS 6 9-89	DAS 28 9-89

ADD D3678-5 x 1 B 148033 (2x) (2 Kits)
per ECN 16-599
DAS 27 9-89 ME 16-621
DAS 28 9-89

JUN 2 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 146824

146824

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 5/26/2016

Required Date: 6/1/2016

Start Qty: 2.00

Required Qty: 2.00

D3678-3

Manufactured No

110

Each

7.0000

1 2

D3678-3

Placard

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

7

139556
145257

2
5

2

D3700-1

Manufactured No

110

Each

4.0000

1 2

D3700-1

Inboard Window Doubler

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

4

112422
113719

2
2

2

D3700-3

Manufactured No

110

Each

1.0000

1 2

D3700-3

Outboard Window Doubler

**

B145 934 X 2

DAS
27

D3701-1

Manufactured No

110

Each

3.0000

1

D3701-1

Floor Doubler

**

Location

Loc Qty

Loc Code

st239

1

113793

1

2

DAS
27
9-89

Location

Loc Qty

Loc Code

st239

3

96231

3

2

910Z 51 NDC

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Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER : _____							
Misidentified	☐	Past Due								

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Work Order ID: 146824

146824

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 5/26/2016

Required Date: 6/1/2016

Start Qty: 2.00

Required Qty: 2.00

D3702-1 Manufactured No 110 Each 2.0000 1 2

D3702-1

Fwd Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

st507

2

110312

2

**

DAS
28
9-89
68-6
9
SWD

D3703-1 Manufactured No 110 Each 8.0000 1 2

D3703-1

Aft Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

ST512

8

113680

8

**

DAS
28
9-89
68-6
9
SWD

D3703-3 Manufactured No 110 Each 6.0000 1 2

D3703-3

Aft Corner Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

st239

6

112397

2

113705

3

144512

1

**

B146153

DAS
28
9-89
68-6
9
SWD

D3703-5 Manufactured No 110 Each 1.0000 1 2

D3703-5

Aft Cap

DAS
27
9-89

Location

Loc Qty

Loc Code

ST052

1

112542

1

**

146016 X1

DAS
28
9-89
68-6
9
SWD

JUN 15 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

Picklist Print

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Work Order ID: 146824

146824

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 5/26/2016

Required Date: 6/1/2016

Start Qty: 2.00

Required Qty: 2.00

D3704-1 Manufactured No

110 Each 2.0000 1 2

D3704-1

Escutcheon

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST052

2

118406

2

D3708-1 Manufactured No

110 Each 2.0000 1 2

D3708-1

Angle

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST235

2

103523

2

D3708-3 Manufactured No

110 Each 2.0000 1 2

D3708-3

Angle

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST235

2

112491

2

D3709-1 Manufactured No

110 Each 1.0000 1 2

D3709-1

Angle

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST235

1

115558

1

D3709-3 Manufactured No

110 Each 0.0000 1 2

D3709-3

Angle

**

DAS
27
9-89

DAS
6
9-89

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

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Shop Packet Print

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

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Work Order ID: 146824

Parent Item: D412-761-045

Parent Item Name: Bubble Window

146824

D412-761-045

Start Date: 5/26/2016

Required Date: 6/1/2016

Start Qty: 2.00

Required Qty: 2.00

D3802-1

Manufactured No

110 f

144.1378 13.5 27

D3802-1

Windows Seal (\$ Per Foot)

DAS
27
9-89

**

DAS
6
9-89
DAS
28
9-89

1X 13S per kit

Location

Loc Qty

Loc Code

ST416

144.13776

134091

0.75

140492

1

141991

5.88776

143804

36.5

145243

50

146267

50

27

DT9458

Manufactured No

110 Each

0.0000 1 2

DT9458

Cutting Template

DAS
27

**

DAS
6
9-89
DAS
28
9-89

AN3-7A 9-89

Purchased No

110 Each 256.0000 26 52

AN3-7A

Bolt

DAS
27
9-89

**

DAS
6
9-89
DAS
28
9-89

Location

Loc Qty

Loc Code

over003

250

m134606

250

ST3349

1

m133694

1

ST349

5

m132803

5

52

JUN 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

Picklist Print

Tuesday, May 24, 2016 9:55:33 AM

Work Order ID: 146824

146824

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 5/26/2016

Required Date: 6/1/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J..

Purchased

No

110

Each

1,799.000

52

104

NAS1149D0363.J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

465

m134055

465

ST260a

1000

m134676

1000

ST263

334

m134606

334

104

DAS
6
9-89

DAS
28
9-89

MS21042L3

Purchased

No

110

Each

1,619.000

26

52

MS21042L3

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

242

m133790

3

m134360

239

ST303

1277

m134039

12

m134360

65

m134634

600

m134754

600

32
20

DAS
6
9-89

DAS
28
9-89

MS24694-C5

Purchased

No

110

Each

100.0000

1

2

MS24694-C5

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

ST285

100

m130238

100

2

DAS
6
9-89

DAS
28
9-89

JUN 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY					
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : _____					
Misidentified ☐		Past Due ☐						

Picklist Print

Page 7

Tuesday, May 24, 2016 9:55:33 AM

Work Order ID: 146824

146824

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 5/26/2016

Required Date: 6/1/2016

Start Qty: 2.00

Required Qty: 2.00

MS24694-C13

Purchased

No

110

Each

13.0000

1 2

MS24694-C13

Screw

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST285

13

108558

13

DAS

27

9-89

2

JUN 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval			
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
										QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :											

6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
									D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
									D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
		X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1					X				D412-761-049	ARMREST KIT, LH
	1					X			D412-761-051	ARMREST KIT, LH
1	1						X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
								X	D412-761-141	VENT KIT
		1							D3589-041	LATCH ASSEMBLY
		1							D3589-047	FORWARD GUIDE
		1							D3589-049	AFT GUIDE
		2							MS16997-24	SCREW
		2							MS21042L06	NUT
		2							NAS1149DN632J	WASHER (OR AN960JD6L)
		1							D3676-1	LARGE BUBBLE WINDOW
		1							D3678-1	PLACARD
		1							D3678-3	PLACARD
		1							D3678-5	PLACARD
		1							D3700-1	INBOARD WINDOW DOUBLER
		1							D3700-3	OUTBOARD WINDOW DOUBLER
		1							D3701-1	FLOOR DOUBLER
		1							D3702-1	FORWARD DOUBLER
		1							D3703-1	AFT DOUBLER
		1							D3703-3	AFT CORNER DOUBLER
		1							D3703-5	AFT CAP
		1							D3704-1	ESCUTCHEON
		1							D3704-3	ESCUTCHEON
		1							D3708-1	ANGLE
		1							D3708-3	ANGLE
		1							D3709-1	ANGLE
		1							D3709-3	ANGLE
		1							D3802-1-135	SEAL
		1							DT9458	CUTTING TEMPLATE
		26							AN3-7A	BOLT
		26							MS21042L3	NUT
		1							MS24694-C5	SCREW (OR MS24694-S5)
		1							MS24694-C13	SCREW (OR MS24694-S13)
		1							NAS43DD3-24	SPACER
		52							NAS1149D0363J	WASHER (OR AN960JD10)

(CONTINUED ON PAGE 12)

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Revision: F
 Date: 16.05.26

5.0 PARTS LIST, MODIFIED FULL VERTICAL REFERENCE DOOR KITS

QTY -011	QTY -011A	QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
X											D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
	X										D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
1		X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	1		X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
				X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
		1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
		1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
		1					X				D412-761-049	ARMREST KIT, LH
			1					X			D412-761-051	ARMREST KIT, LH
		1	1						X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1	1									X	D412-761-141	VENT KIT
1	1										204-030-853-125 OR 204-030-853-137 OR 204-030-853-155 OR 204-030-853-153	BELL 204, 205, 210, 412 OEM DOOR

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Revision: F
Date: 16.05.26

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Quality Control